



Dart Aerospace Ltd.
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D3914-041
Job Sheet 186791



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Large Fab-5		12/28/18
100	Large Fab	1 pcs	12/7/18	12/7/18	0.00	6.67	Large Fab 1		12/28/18
110	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC9		
120	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC5		
130	Powdercoat	1 pcs	12/7/18	12/7/18	0.00	0.40	Powdercoat4		18-06-2
135	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC3		05-03-0
140	HandFinish	1 pcs	12/7/18	12/7/18	0.00	0.80	HandFinish3		BE 819-01-0AS
150	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC3		JAN 08 2019 68
160	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-2		BE 819-01-0AS
170	QC21-SA	1 Ea	12/7/18	12/7/18	0.00	0.00	QC21		21 JAN 08 2019

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M138859.

START: 10:30

OUT: 3:00 FINISH: 11:00.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5125289
D3914-1	Rib	2 Ea (2 ea)	90-Start up Operation	5132039
D3914-7	Rib	2 Ea (2 ea)	90-Start up Operation	5125626
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	5121277
D4018-5	Rib	9 Ea (9 ea)	90-Start up Operation	5134802
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	5137016
D4021-3	Data Plate	1 Ea (1 ea)	90-Start up Operation	5114284
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea)	90-Start up Operation	5131645

wing walk M138963.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

90-Start up Operation

D2581	2	58	0
D3914-1	2	8	0
D3914-7	2	10	0
D4016-3	3	205	0
D4018-5	9	27	0
D4020-5	1	2	0
D4021-3	1	19	0
D4035-043	2	8	0

Part Specifications

Specifications could not be found.

Plex 11/21/18 10:49 AM Dart.lajeunesse.marie



Container No: S140695



Part: D3914-041

Job No: 186791

Serial No/Batch: S140695

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/28/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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QC / QA Coordinator Approval																					
Root Cause			FAULT CATEGORY																		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
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